

**Work Order ID 70943**

Monday, June 20, 2011 8:50:57 AM

Page 1

Item ID: D3414-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug Assembly

Start Date: 6/20/2011 Start Qty: 4.00

Required Date: 7/4/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-6-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3414-1

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

0.00

B11-6-20

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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Item ID: D3414-041      Accept            Setup      Start        
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Start Date: 6/20/2011      Start Qty: 4.00            Cust Item ID:  
Required Date: 7/4/2011      Req'd Qty: 4.00            Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start        
QC:      Date:      SPC (Y/N):      Date:      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		511606/21		(X)13			
130  Brake NC Brake NC	Memo 1-Debur 2-Form using DT8254 as per Dwg D3414	0.00  0.00		SB 11606/21		(13)			
140  Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M117659	0.00  0.00				Q 167-7		(X)13	

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Item ID: D3414-041

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Setup Start



Revision ID:

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Item Name: Lug Assembly

Start Date: 6/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

11.02.07 13

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.10.07

11 07 13

175



SprayPaint

Spray Painting

Memo

PRIME B 117319  
DELFLEET BLUE B 115985  
DELFLEET CLEAR B 117113

0.00

0.00

11 07 13 4 13

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

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Item Name: Lug Assembly

Start Date: 6/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

185

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

11-07-14 (13)

190

Identify as per dwg &amp; Stock Location: 420

0.00



Packaging

Memo

0.00

Packaging

11-07-14 (13)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-07-14

MF 11-07-14

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 20, 2011 8:51:04 AM

Page 1

Work Order ID: 70943

Parent Item: D3414-041

Parent Item Name: Lug Assembly



Start Date: 6/20/2011

Required Date: 7/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA  304/316 0.100" Sheet		Purchased	No			100	sf	150.3000	0.155	0.62			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		150.3							
				113062		118.3							
				113077		32							
D3414-3  Lug		Manufactured	No			140	Each	21.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		21							
				69882		21							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

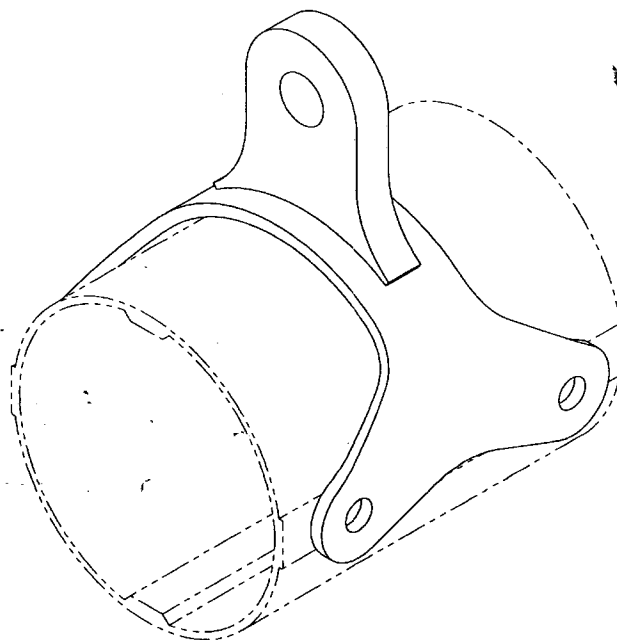
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70943  
PL11-dr-20



**D3414-041 LUG ASSEMBLY**

**RELEASED**  
8/1/86/05/14

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR188). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 1 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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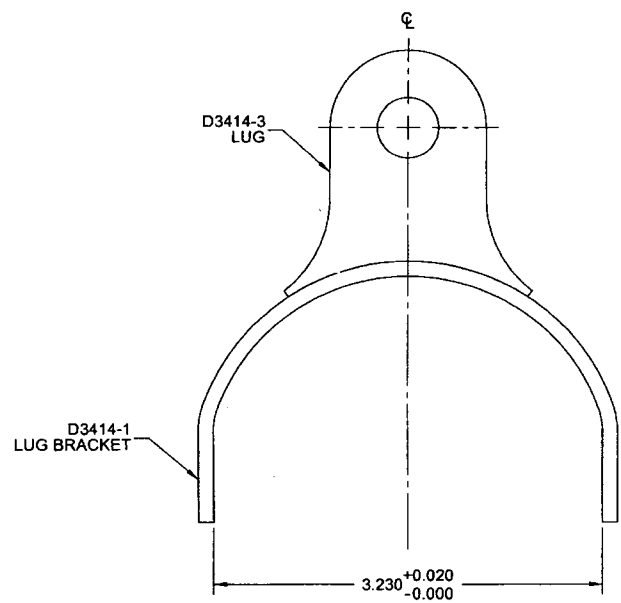
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

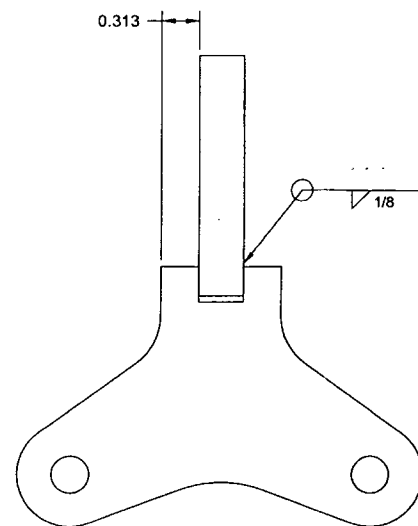
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W 70943



**D3414-041 LUG ASSEMBLY**



**RELEASED**

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	ED	DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.	ED		SHEET 2 OF 3
APPROVED	ED	TITLE <b>LUG ASSEMBLY</b>	SCALE
DE APPR.	ED		NTS
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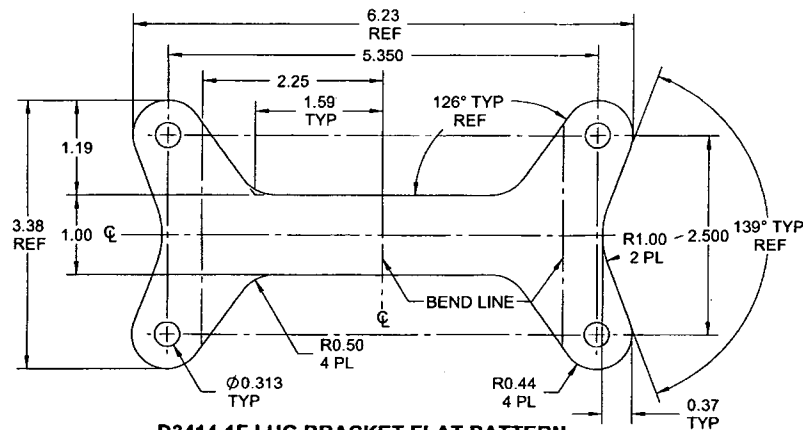
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

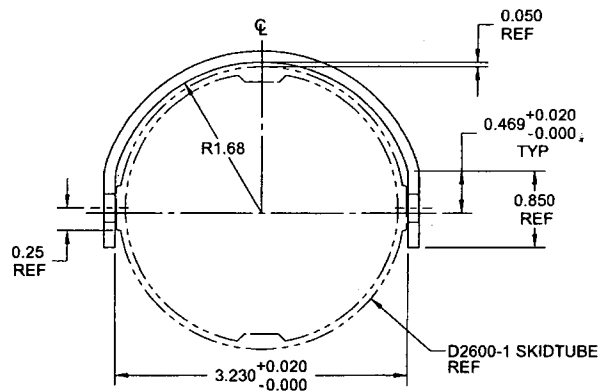
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**NOTE:** Date & initial all entries





**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**

**NOTES:**

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

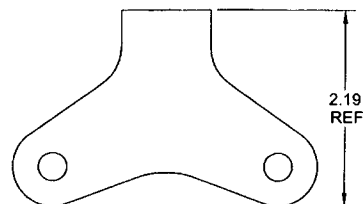
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

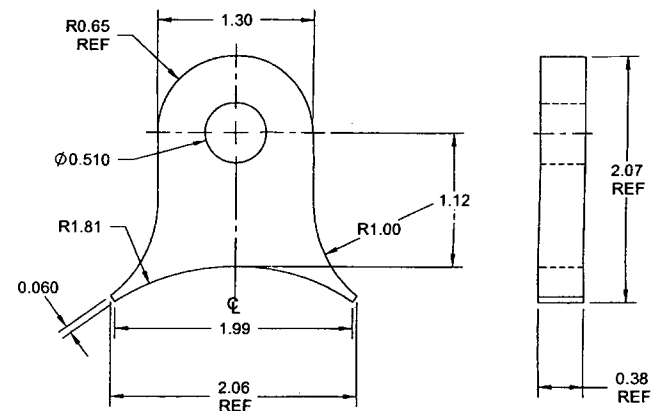
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



**SIDE VIEW FOR REF ONLY**



**D3414-3 LUG**

**RELEASED**  
09/06/17

DESIGN	QP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.	CP	SHEET 3 OF 3	
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	<b>LUG ASSEMBLY</b>	NTS
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